

Work Order ID 72355

Friday, July 22, 2011 2:50:56 PM



Page 1

Item ID: D206-628-022

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH

Start Date: 7/22/2011 Start Qty: 2.00




Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: 

Date: 7-27-22 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-022 CHG 003

S 11/29/14

JG BG 11-8-12

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

C 11/24/10 (2)

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

S 11/29/14

72
R4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-628-022

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Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH

Start Date: 7/22/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-022 Location: <u>71 A</u> PPP Rev: _____								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/9/14

11/9/15

mf
11-09-15

72357

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, July 22, 2011 2:51:14 PM

Work Order ID: 72355

Parent Item: D206-628-022

Parent Item Name: Heli-Access-Step RH



Start Date: 7/22/2011

Start Qty: 2.00

Required Date: 7/29/2011

Required Qty: 2.00

Comments: IPP Rev:D as per ECN 766 JLM
 IPP Rev:E as per ecn 1118 DD verified by:EC IPP Rev:F
 10.08.13 CHG QTY OF RUBBER DD verf by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD416 Washer D2724-042 206L Step Assembly AN4-14A Bolt	NAS1149D0463J	Purchased	No				Each	0.0000		24 ✓			
										118179 JB			
		Manufactured	No				Each	0.0000		2			
										72357 B 11/9/11			
		Purchased	No			120	Each	143.0000	4	8 ✓			
										JB			

Location	Loc Qty	Loc Code
ST357	143	
117872	143	

AN4-15A Bolt	Purchased	No			120	Each	295.0000	8	16 ✓				
-----------------	-----------	----	--	--	-----	------	----------	---	------	--	--	--	--

Location	Loc Qty	Loc Code
ST357	195	
117423	195	
ST358	100	
118112	100	

JB 11/08/10
 117423

542
 11/9/11

542

Handwritten signature

Handwritten signature

Handwritten signature

Handwritten signature

Handwritten signature

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Friday, July 22, 2011 2:51:14 PM

Work Order ID: 72355

Parent Item: D206-628-022

Parent Item Name: Heli-Access-Step RH

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

D2731-7 Manufactured No 120 Each 67.0000 4 8 ✓



Mounting Lug

Location	Loc Qty	Loc Code
ST420	4	
71083	4	
ST470	63	
62929	19	
66427	32	
69177	12	



JB

[Signature]

D2732-030 Manufactured No 120 Each 6.0000 8 16 ✓



Rubber Cushion

QA Qty +8 per kit @ 3.00 each -> measure 1/16

Location	Loc Qty	Loc Code
ST402	6	
69205	6	



62929 48

66427 48

64283 JB

YF-RAT

[Signature]

D3394-043 Manufactured No 120 Each 89.0000 4 8 ✓



Lug Assembly

Location	Loc Qty	Loc Code
ST420	2	
71082	2	
ST475	87	
62930	12	
62976	28	
66429	34	
69180	13	



62930 68

62976 28

JB

11/08/10 *[Signature]*

Friday, July 22, 2011 2:51:15 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Friday, July 22, 2011 2:51:15 PM

Work Order ID: 72355



Parent Item: D206-628-022



Parent Item Name: Heli-Access-Step RH

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

120

Each

3,673.000

12

24



Nut



25 11/08/10

Location

Loc Qty

Loc Code

ST300

3673

117441

1426

117601

747

117885

1500

117441

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

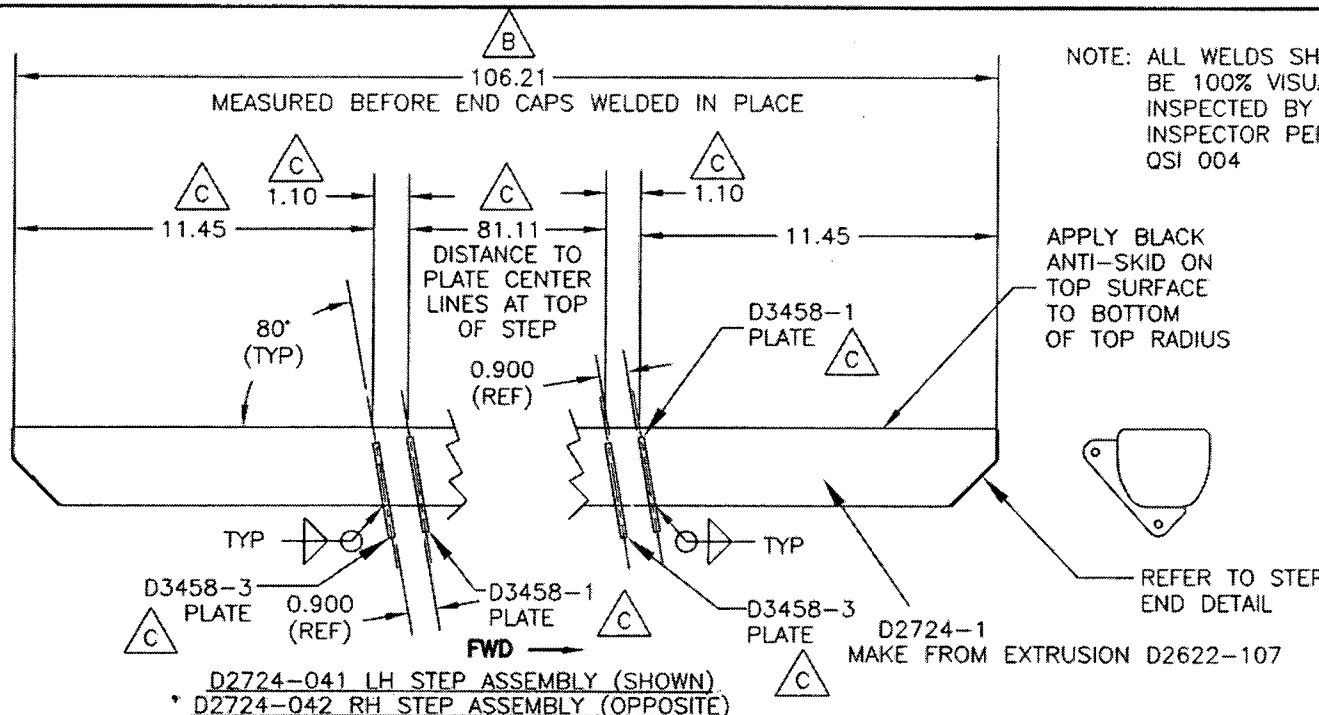
REFERENCE ONLY

DART

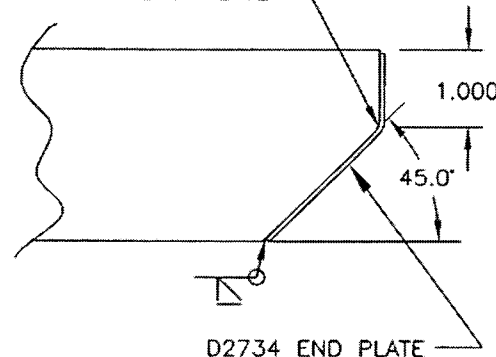
RELEASED
05.11.14

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19	TITLE	206L/407 STEP ASSEMBLY	REV. C
	A		97.12.04	NEW ISSUE
	B		98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES
	C		05.09.19	RE-DESIGN, ADD D3458-1/-3
		SCALE	NTS	

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2724-041	LH STEP ASSEMBLY
		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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